



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2850-1
Job Sheet 174177



Part No: D2850-1

Job Qty: 15 Ea

Part Name: End Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP B 98.12.07 Changed folio DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		4/12/18	0.00	0.00	Start Up Machining-1		<i>[Signature]</i>
100	Bandsaw	8 pcs		4/12/18	0.00	0.07	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	8 pcs		4/13/18	0.20	5.59	HAAS1-2		<i>[Signature]</i>
130	QC	8 pcs		4/13/18	0.00	0.00	QC8 Machining-1		<i>[Signature]</i>
140	Packaging	8 pcs		4/13/18	0.00	0.00	Packaging3-1		<i>[Signature]</i>
150	QC21-SA	8 Ea		4/13/18	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut blanks: 3.8"

Descriptions: 110 - Machine per Folio D2850-1 Deburr and Tumble

140 - *** STOCK IN STEP CELL***

DAS
21
9-80

APR 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	2.4000 ft (.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X01.500	2	8	0

1.500 x 2.500



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HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S063969



Part: D2850-1

Job No: 174177

Serial No/Batch: S063969

Revision:

Inspector:

Date: 04/23/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	High Float Step End Bracket	1.720inches + 0.000 - 0.030	1.720 1.690		
2	High Float Step End Bracket	0.178inches ± 0.010	0.188 0.168		
3	High Float Step End Bracket	0.100inches ± 0.030	0.130 0.070		
4	High Float Step End Bracket	30.000Degrees ± 0.500	30.500 29.500		
5	High Float Step End Bracket	2.150inches ± 0.030	2.180 2.120		
6	High Float Step End Bracket	0.375inches + 0.010 - 0.100	0.385 0.275		
7	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115		
8	High Float Step End Bracket	1.000inches ± 0.030	1.030 0.970		
9	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115		
10	High Float Step End Bracket	19.200Degrees ± 0.500	19.700 18.700		
11	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115		
12	High Float Step End Bracket	0.750inches ± 0.010	0.760 0.740		
13	High Float Step End Bracket	0.600inches ± 0.010	0.610 0.590		

Plex 3/12/18 12:38 PM dart.lacelle.linda

DQA: _____ Date: _____



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Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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